

Work Order ID 160934

Friday, May 05, 2017 10:20:08 AM

160934

Page 1

Item ID: PB67-43001-207W

Revision ID:

Item Name: Square Tube Weldment

Start Date: 5/11/2017 Start Qty: 1.00

Required Date: 5/15/2017 Req'd Qty: 7.00

Reference: SCHEDULED/U

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: **DAS 21 9-89** Date: **MAY 05 2017**QC: **DAS 21 9-89** Date: SPC (Y/N):

Date:

Date:

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001-07	D

110

Weld per dwg A/R Aluminum rod Batch: **131562** 0.00***110***

Large Fab

Large Fab

Memo

- 1- Cut to length as per dwg
- 2- Make a chamfer on both ends of tube
- 3- Drill holes as per dwg use drill jig DT10022
- 4- Make a chamfer on both side of the 4 holes
- 5- Deburr
- 6- Grind weld flush as per dwg

0.00

JUN 12 2017**DAS 24 9-89****2****2****MAY 29 2017****DAS 19 9-89**

130

QC10- Inspect visual per QSI004- ground welds 0.00

130

QC

Quality Control

Memo

0.00

2**DAS 38 9-89****JUN 12 2017**

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

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Page 2

Item ID: PB67-43001-207W

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Square Tube Weldment

Start Date: 5/11/2017 Start Qty: 7.00

7

Cust Item ID:

Required Date: 5/15/2017 Req'd Qty: 7.00

7

Customer:

Reference: SCHEDULED/U

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
135	QC5- Inspect part completeness to step on W/O	0.00							
135									
QC	Memo	0.00							
Quality Control									JUN 12 2017
140	Identify as per dwg & Stock Location: <u>WA3</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									



JUN 12 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
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Misidentified ☐	Past Due ☐								
		OTHER : ☐							

Picklist Print

Friday, May 05, 2017 10:20:08 AM

Page 1

Work Order ID: 160934

160934

Parent Item: PB67-43001-207W

PR67-43001-207W

Parent Item Name: Square Tube Weldment

Start Date: 5/11/2017

Required Date: 5/15/2017

Start Qty: 7.00

Required Qty: 7.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6TS1.000W.12		Purchased	No			110	f	13.5907	1.8542	13.66253			DAS 19 9-89

✓ ***M6061T6TS1 000W 125***

6061T6 SQ TUBE 1.00 x 1.00 x .125w

**

MAY 29 2017

Location	Loc Qty	Loc Code
MAT028	13.59069	
m128034	13.59069	

✓ PB67-43001-223

Manufactured No

✓ ***PR67-43001-223***

Square Cap

**

JUN 12 2017

DAS
24
9-89

Location	Loc Qty	Loc Code
Mezz2	2	
152152	2	

✓ PB67-43001-225

Manufactured No

✓ ***PR67-43001-225***

Bushing

**

JUN 12 2017

DAS
24
9-89

Location	Loc Qty	Loc Code
Mezz2	23	
148791	23	

B160956

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

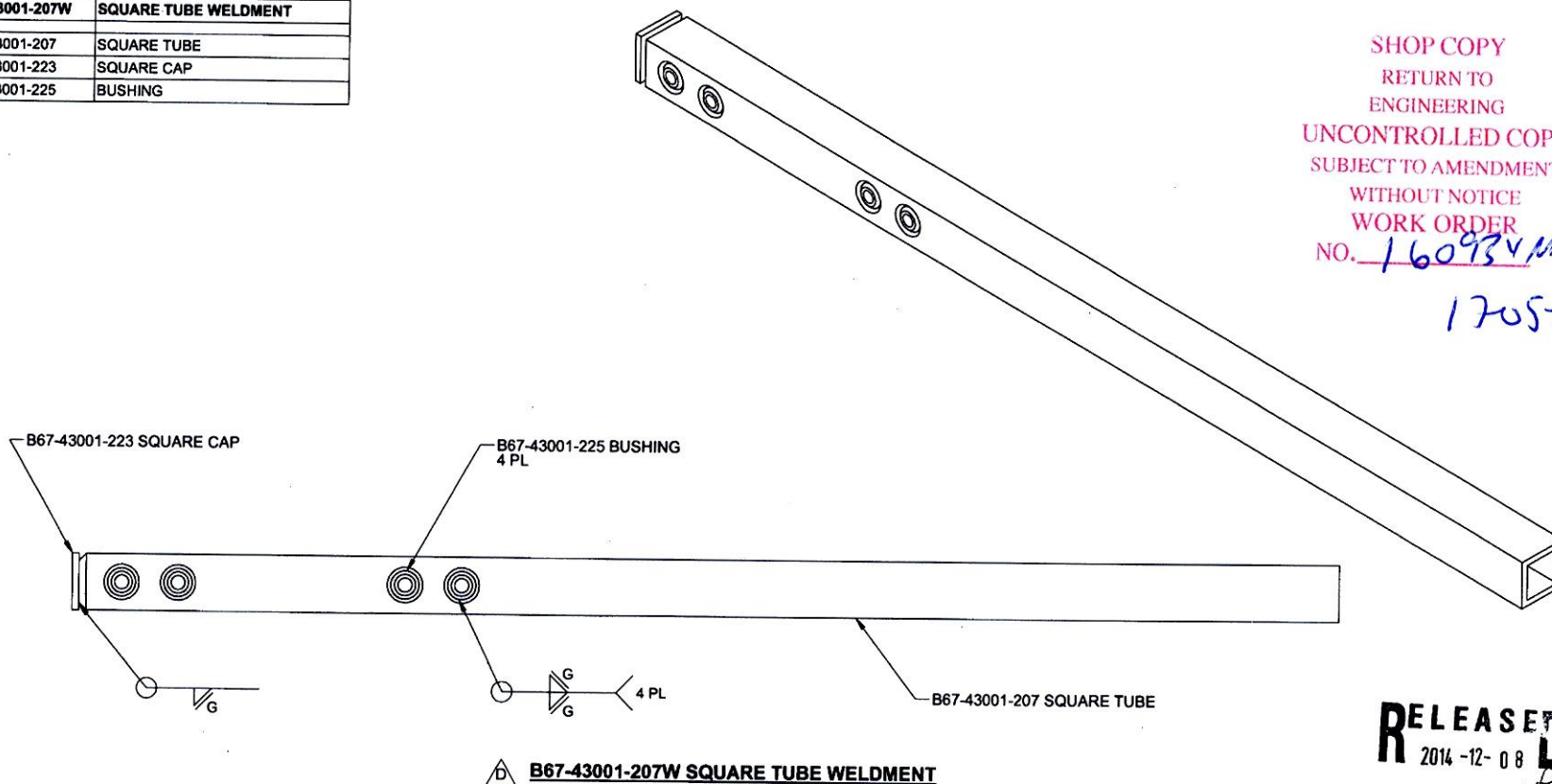
QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																																

ITEM	QTY -207W	P/N	DESCRIPTION
	X	B67-43001-207W	SQUARE TUBE WELDMENT
1	1	B67-43001-207	SQUARE TUBE
2	1	B67-43001-223	SQUARE CAP
3	4	B67-43001-225	BUSHING

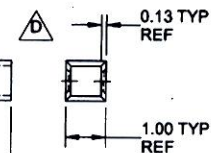
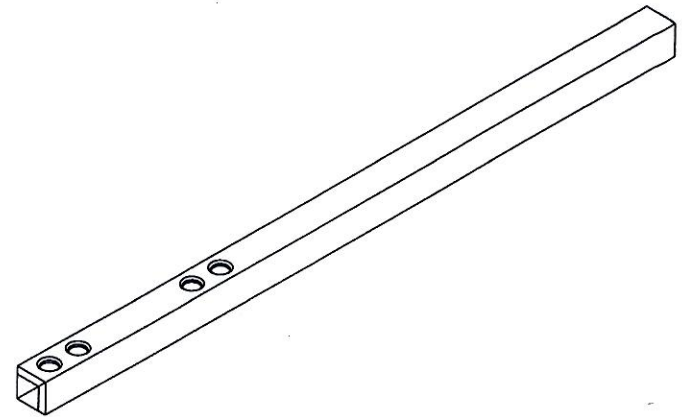
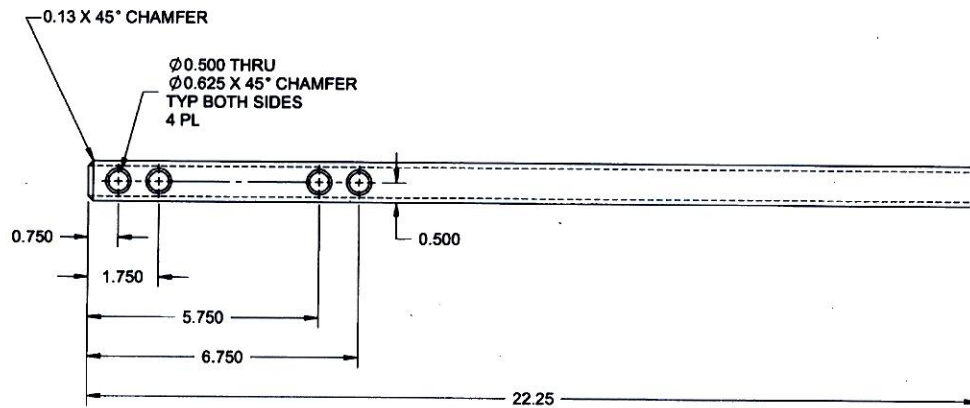
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 160934MLS
170505



RELEASED
2014-12-08
VJP

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.99 lbs
8) WELDING: PER DART QSI 004

D	ADD -207W WELDMENT. REMOVE CHAMFER (ZNC4-2) REASON: TO FACILITATE MANUFACTURING	DB	14.07.22
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 16 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-207	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	SQUARE TUBE	NTS
DATE	14.07.22	COPYRIGHT © 1995 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



B67-43001-207 SQUARE TUBE

RELEASED
2014-12-08

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6TS1.000W0.125
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.92 lbs

DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		B67-43001-207	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	SQUARE TUBE	NTS
DATE	14.07.22	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	